

Date: Tuesday, 03/02/2009 2:48:59 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 45472
Estimate Number : 13768
P.O. Number :
This Issue : 03/02/2009 **S.O. No.** :
Prsht Rev. : NC
First Issue : / / **Type** : LARGE FAB ASSY
Previous Run :
Written By :
Checked & Approved By : JLD 09-02-03
Comment : Est Rev:A 09-02-03 new issue DD verified by:EC
Drawing Name : WEARPLATE
Part Number : D3859041
Drawing Number : D3859 REV.A
Project Number : N/A
Drawing Revision : A
Material :
Due Date : 2002/2009 **Qty:** 10 **Um:** Each
 (add one for Template)

Additional Product

Job Number:



Seq. #: **Machine Or Operation:** **Description :**

1.0 M304S16GA 304/316 Sheet .063



Comment: Qty.: 0.8552 sf(s)/Unit Total : 8.5523 sf(s)
 304/316 .063 Sheet
 Batch: 110551 18 9-2-4

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg D3859
 Dwg Rev: A
 Prog Rev: A

18 9-2-4

2-Deburr if necessary 18 9-2-4

(12)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



18 9-2-4



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

509/02/05 (12)

5.0 D30093 Cup



Comment: Qty.: 6.0000 Each(s)/Unit Total : 60.0000 Each(s)
 CUP
 Batch: B42376

EL 9-2-25 (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 03/02/2009 2:48:59 PM
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Drawing Name: WEARPLATE

Job Number: 45472

Part Number: D3859041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld D3009-3 cups as per dwg D3859

A/R 316L stainless steel rod Batch: M107051

2-Weld hard facing as per Dwg D3859

A/R 2059B Hard Coat rod Batch: M107963

EL 9-2-28

7.0

QC9

VISUAL WELDING INSPECTION



(X12)

Comment: VISUAL WELDING INSPECTION

Pl 09-03-02

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 09/03/02 (X2)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME: 7:00

OVEN TEMPERATURE: 320°

FINISH TIME: 7:30

FL 09/03/04

(12)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(12)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 09-03-4

11.0

PACKAGING 1

PACKAGING RESOURCE #1



(12)

Comment: PACKAGING RESOURCE #1

Identify with Dart P/N and B/N using a permanent fine point marker as indicated on dwg, then Stock

Location: 500

9/3/4

50

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/05

Job Completion



MF 09-03-04

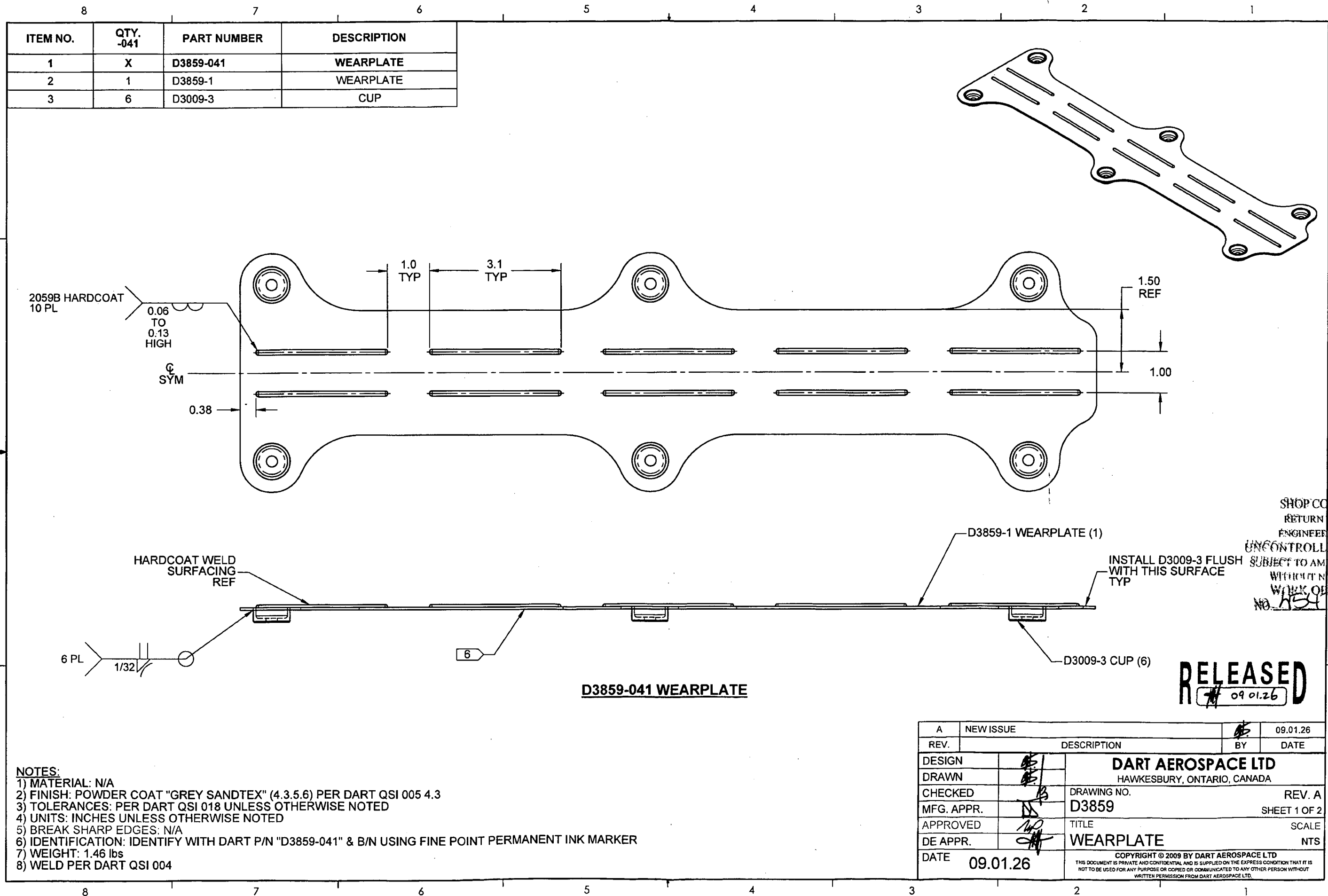
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

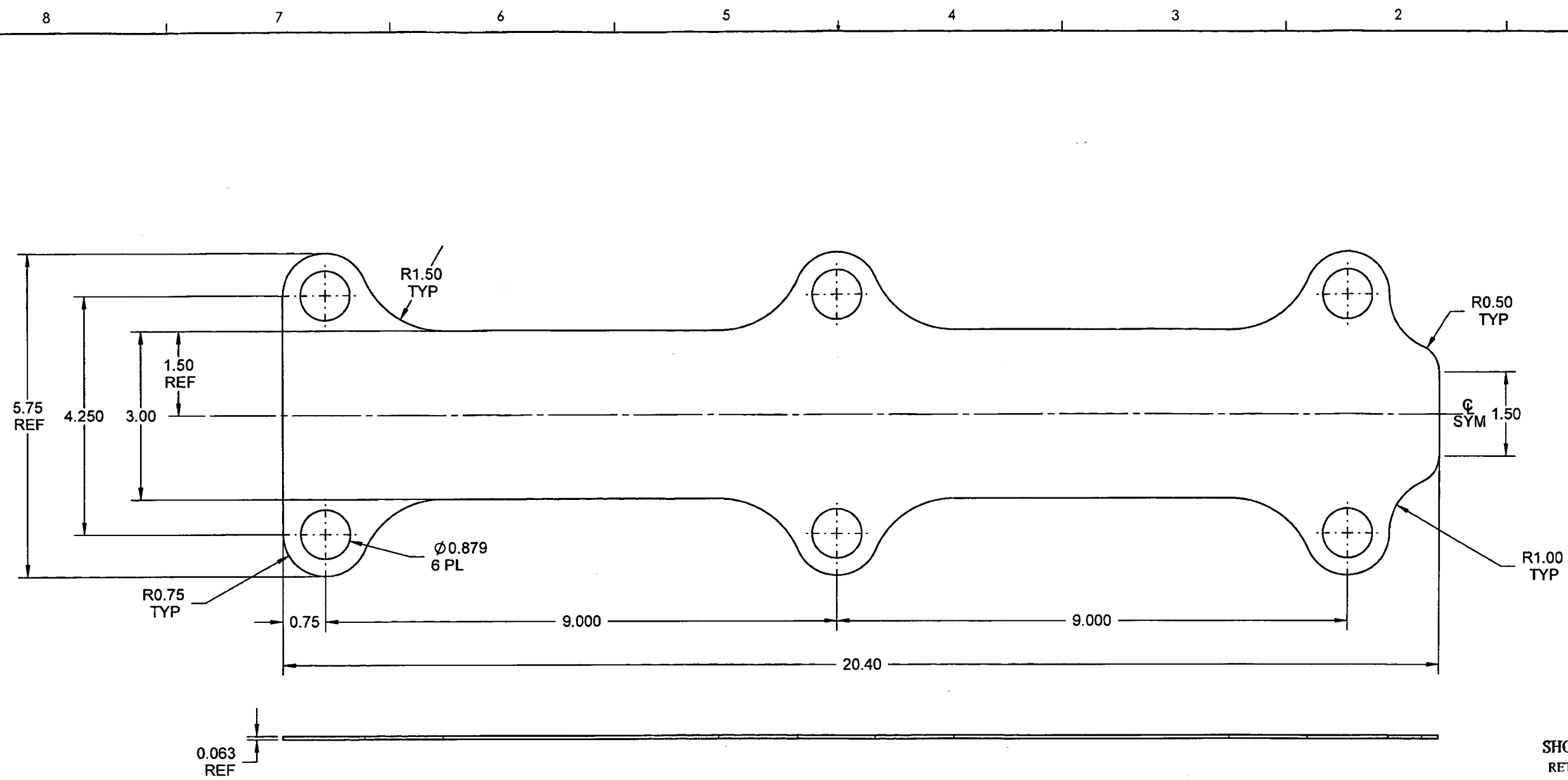
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries











D3859-1 WEARPLATE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO APPROVAL
NO. 45472

RELEASED
7/09.01.26

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 16 GAUGE (0.063 THICK), PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524 (REF DART SPEC M304S16GA)
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.29 lbs

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. REV. A
MFG. APPR.		D3859 SHEET 2 OF 2
APPROVED		TITLE SCALE
DE APPR.		WEARPLATE NTS
DATE	09.01.26	COPYRIGHT © 2009 BY DART AEROSPACE LTD
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